



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D4034-041**  
**Job Sheet 188246**



Part No: D4034-041

Job Qty: 4 pcs

Part Name: Aft Upper Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 1/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

**Note:** DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA  
10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER  
DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation                     | Qty             | Start Date         | Due Date           | Standard        |                 | Workcenter/Supplier             |           | Sign-off |
|-------|-------------------------------|-----------------|--------------------|--------------------|-----------------|-----------------|---------------------------------|-----------|----------|
|       |                               |                 |                    |                    | Setup Hrs       | Run Hrs         | Workcenter / Supplier           | Lead Time |          |
| 90    | <del>Start up Operation</del> | <del>4 Ea</del> | <del>1/21/19</del> | <del>1/21/19</del> | <del>0.00</del> | <del>0.00</del> | <del>Start Up Large Fab-6</del> |           |          |
| 100   | Large Fab - Basket - 1        | 4 pcs           | 1/21/19            | 1/21/19            | 0.00            | 4.60            | Large Fab - 1                   |           |          |
|       |                               |                 |                    |                    |                 |                 | Large Fab - 10                  |           |          |
|       |                               |                 |                    |                    |                 |                 | Large Fab - 2                   |           |          |
|       |                               |                 |                    |                    |                 |                 | Large Fab - 3                   |           |          |
|       |                               |                 |                    |                    |                 |                 | Large Fab - 4                   |           |          |
|       |                               |                 |                    |                    |                 |                 | Large Fab - 5                   |           |          |
|       |                               |                 |                    |                    |                 |                 | Large Fab - 6                   |           |          |
|       |                               |                 |                    |                    |                 |                 | Large Fab - 7                   |           |          |
|       |                               |                 |                    |                    |                 |                 | Large Fab - 8                   |           |          |
|       |                               |                 |                    |                    |                 |                 | Large Fab - 9                   |           |          |
| 110   | QC 9                          | 4 pcs           | 1/21/19            | 1/21/19            | 0.00            | 0.00            | QC 9 - 10                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 9 - 18                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 9 - 24                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 9 - 43                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 9 - 50                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 9 - 9                        |           |          |
| 120   | QC 5                          | 4 pcs           | 1/21/19            | 1/21/19            | 0.00            | 0.00            | QC 5 - 10                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 5 - 12                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 5 - 17                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 5 - 18                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 5 - 19                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 5 - 22                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 5 - 24                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 5 - 3                        |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 5 - 38                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 5 - 42                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 5 - 43                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 5 - 49                       |           |          |
|       |                               |                 |                    |                    |                 |                 | QC 5 - 51                       |           |          |

|                                       |         |           |           |                        |      |
|---------------------------------------|---------|-----------|-----------|------------------------|------|
|                                       |         |           |           | QC 5 - 58              |      |
|                                       |         |           |           | QC 5 - 68              |      |
|                                       |         |           |           | QC 5 - 9               |      |
|                                       |         |           |           | QC 5 - 50              |      |
|                                       |         |           |           | QC 5 - 30              |      |
| 130 Packaging 3-1 - Stock - B4B 4 pcs | 1/21/19 | 0.00 0.00 |           | Packaging 3 - 1 - B4B  |      |
|                                       |         |           |           | Packaging 3 - 2 - B4B  |      |
|                                       |         |           |           | Packaging 3 - 3 - B4B  |      |
|                                       |         |           |           | Packaging 3 - 4 - B4B  |      |
|                                       |         |           |           | Packaging 3 - 5 - B4B  |      |
|                                       |         |           |           | Packaging 3 - 6 - B4B  |      |
|                                       |         |           |           | Packaging 3 - 7 - B4B  |      |
|                                       |         |           |           | Packaging 3 - 8 - B4B  |      |
|                                       |         |           |           | Packaging 3 - 9 - B4B  |      |
|                                       |         |           |           | Packaging 3 - 10 - B4B |      |
|                                       |         |           |           | Packaging 3 - 11 - B4B |      |
|                                       |         |           |           | Packaging 3 - 12 - B4B |      |
|                                       |         |           |           | Packaging 3 - 13 - B4B |      |
|                                       |         |           |           | Packaging 3 - 14 - B4B |      |
|                                       |         |           |           | Packaging 3 - 15 - B4B |      |
|                                       |         |           |           | Packaging 3 - 16 - B4B |      |
|                                       |         |           |           | Packaging 3 - 17 - B4B |      |
|                                       |         |           |           | Packaging 3 - 18 - B4B | DAS  |
|                                       |         |           |           | Packaging 3 - 19 - B4B | 43   |
|                                       |         |           |           | Packaging 3 - 20 - B4B | 9-89 |
|                                       |         |           |           | Packaging 3 - 21 - B4B |      |
|                                       |         |           |           | Packaging 3 - 22 - B4B |      |
|                                       |         |           |           | Packaging 3 - 23 - B4B |      |
|                                       |         |           |           | Packaging 3 - 24 - B4B |      |
|                                       |         |           |           | Packaging 3 - 25 - B4B |      |
|                                       |         |           |           | Packaging 3 - 26 - B4B |      |
|                                       |         |           |           | Packaging 3 - 27 - B4B |      |
|                                       |         |           |           | Packaging 3 - 28 - B4B |      |
|                                       |         |           |           | Packaging 3 - 29 - B4B |      |
|                                       |         |           |           | Packaging 3 - 30 - B4B |      |
|                                       |         |           |           | Packaging 3 - 31 - B4B |      |
|                                       |         |           |           | Packaging 3 - 32 - B4B |      |
|                                       |         |           |           | Packaging 3 - 33 - B4B |      |
|                                       |         |           |           | Packaging 3 - 34 - B4B |      |
|                                       |         |           |           | Packaging 3 - 35 - B4B |      |
|                                       |         |           |           | Packaging 3 - 36 - B4B |      |
| 140 QC 21 - SA                        | 4 pcs   | 1/21/19   | 0.00 0.00 | QC 21 - SA - 21        |      |
|                                       |         |           |           | QC 21 - SA - 70        |      |

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: 136920) 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld  
 Descriptions: bushing in rib and grind weld flush as per dwg  
 110 - (QC9- Inspect visual per QSI004- Fusion Welds)  
 120 - (QC5- Inspect part completeness to step on W/O)  
 130 - (Identify as per dwg & Stock Location: \_\_\_\_\_) LOCATION: WA004  
 140 - (QC21- Final Inspection - Work Order Release)

#### Job BOM

| Part / Item | Component Name | Quantity                 | Operation             | Container       |
|-------------|----------------|--------------------------|-----------------------|-----------------|
| D4021-7     | Hoop           | 4 pcs (1 ea) <u>3</u>    | 90-Start up Operation | <u>5150 285</u> |
| D4021-9 ✓   | Bushing        | 16 pcs (4 ea) <u>-12</u> | 90-Start up Operation | <u>5115 312</u> |
| D4034-1 ✓   | Rib            | 4 pcs (1 ea) <u>-3</u>   | 90-Start up Operation | <u>5160 156</u> |
| D4034-3 ✓   | Rib            | 4 pcs (1 ea) <u>✓3</u>   | 90-Start up Operation | <u>5159 634</u> |

| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 90-Start up Operation              | D4021-7        | 4        | 18        | 0         |
|                                    | D4021-9        | 16       | 319       | 0         |
|                                    | D4034-1        | 4        | 17        | 0         |
|                                    | D4034-3        | 4        | 13        | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

Plex 1/22/19 8:24 AM Dart.Hadley.Shannon





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**D4034-041**  
**Job Sheet 188246**



Part No: D4034-041

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Part Name: Aft Upper Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 1/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA  
10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER  
DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 4 Ea  | 1/21/19    | 1/21/19  | 0.00      | 0.00    | Start Up Large Fab-6  |           |          |
| 100   | Large Fab          | 4 pcs | 1/21/19    | 1/21/19  | 0.00      | 4.60    | Large Fab 1           |           |          |
| 110   | QC                 | 4 pcs | 1/21/19    | 1/21/19  | 0.00      | 0.00    | QC9                   |           |          |
| 120   | QC                 | 4 pcs | 1/21/19    | 1/21/19  | 0.00      | 0.00    | QC5                   |           |          |
| 130   | Packaging          | 4 pcs | 1/21/19    | 1/21/19  | 0.00      | 0.00    | Packaging3 Large Fab  |           |          |
| 140   | QC21-SA            | 4 Ea  | 1/21/19    | 1/21/19  | 0.00      | 0.00    | QC21                  |           |          |

Part Op 100 - 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld bushing in rib and grind weld flush as per dwg  
Descriptions: 130 - LOCATION: WA004

### Job BOM

| Part / Item | Component Name | Quantity      | Operation             | Container |
|-------------|----------------|---------------|-----------------------|-----------|
| D4021-7     | Hoop           | 4 pcs (1 ea)  | 90-Start up Operation |           |
| D4021-9     | Bushing        | 16 pcs (4 ea) | 90-Start up Operation |           |
| D4034-1     | Rib            | 4 pcs (1 ea)  | 90-Start up Operation |           |
| D4034-3     | Rib            | 4 pcs (1 ea)  | 90-Start up Operation |           |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D4021-7        | 4        | 15        | 0         |
|                       | D4021-9        | 16       | 415       | 0         |
|                       | D4034-1        | 4        | 12        | 0         |
|                       | D4034-3        | 4        | 8         | 0         |

### Part Specifications

Specifications could not be found.

Plex 1/4/19 1:11 PM Dart.lajeunesse.marie

LFC



Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |  |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div> |  |  |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   | MRB (QSI042)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |  |  |
| <div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p style="font-size: small;">DART Aerospace Ltd.<br/>1270 Aberdeen Street<br/>Hawkesbury, ON K6A 1K7<br/>CANADA<br/>TEL.: 1 613 832-5200<br/>Email: sales@dartaero.com<br/>www.dartaerospace.com</p> <p style="font-size: x-small;"><b>Root Cause</b></p> <p style="font-size: x-small;">Manufacturing Equip, _____</p> <p style="font-size: x-small;">Handling/Presservation _____</p> <p style="font-size: x-small;">Material _____</p> <p style="font-size: x-small;">Product Improvement _____</p> <p style="font-size: x-small;">Process Improvement _____</p> <p style="font-size: x-small;">Human Factors _____</p> </div> <div style="width: 50%;"> <p style="font-size: small;">Date: 03/19/19</p> <p style="font-size: small;">Instructions: Various STC's</p> <p style="font-size: small;">Other/Details: _____</p> </div> </div> |                                                                                                                                   | Completed By                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                   | Lead hand / Supervisor                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                   | QC / QA Coordinator                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |  |  |
| <div style="display: flex;"> <div style="flex: 1;"> <p style="font-size: small;">Container No: S163889</p> <p style="font-size: small;">Part: D4034 - 041</p> <p style="font-size: small;">Job No: 188246</p> <p style="font-size: small;">Serial No/Batch: S163889</p> <p style="font-size: small;">Revision: _____</p> <p style="font-size: small;">Inspector: _____</p> <p style="font-size: small;">Exp Date: _____</p> </div> <div style="flex: 1;"> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                   | <div style="display: flex; justify-content: space-between;"> <div> <p>Power Loss/Surge <input type="checkbox"/></p> <p>Folio/Program <input type="checkbox"/></p> <p>Grain Direction <input type="checkbox"/></p> <p>Weld <input type="checkbox"/></p> <p>Wrong Stock Pulled <input type="checkbox"/></p> <p>Out of Sequence <input type="checkbox"/></p> <p>Off-set/Set-up <input type="checkbox"/></p> </div> <div> <p>Positioned Wrong <input type="checkbox"/></p> <p>Outside Tolerance <input type="checkbox"/></p> <p>Drawing <input type="checkbox"/></p> <p>Finish <input type="checkbox"/></p> <p>Part Lost/Missing <input type="checkbox"/></p> <p>Misread <input type="checkbox"/></p> </div> </div>                                                                                                                      |  |  |  |